



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-5
Job Sheet 180484



Part No: D3065-5

Job Qty: 80 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea		7/31/18	0.00	0.00	Start Up Waterjet		SL 8/10/18
100	Waterjet	80 pcs		7/31/18	0.02	7.37	Waterjet1		SL 8/10/18
120	QC	80 pcs		7/31/18	0.00	0.00	QC8		38
130	HandFinish	80 pcs		7/31/18	0.00	1.81	HandFinish1		SA 7-8-07-16
140	QC	80 pcs		7/31/18	0.00	0.00	QC7-1		25
150	Packaging	80 pcs		7/31/18	0.00	0.00	Packaging3		25
160	QC21-SA	80 Ea		7/31/18	0.00	0.00	QC21		25

Part Op 100 - 1-Cut as per Dwg
Descriptions: 150 - LOCATION : GA

DAS 53 9-89
JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	66 sf (.825 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	66	251	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches $\pm$ 0.010	16.468 16.448	16, 460	
2	Step Log	15.750inches $\pm$ 0.005	15.755 15.745	15, 75	
3	Step Log	2.250inches $\pm$ 0.005	2.255 2.245	2, 251	
4	Step Log	3.460inches $\pm$ 0.005	3.465 3.455	3, 462	
5	Step Log	0.865inches $\pm$ 0.005	0.870 0.860	0, 867	
6	Step Log	6.020inches $\pm$ 0.005	6.025 6.015	6, 021	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCI _____ Date : _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;"> ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite </td> <td style="width: 33%;"> ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier </td> <td style="width: 33%;"> ☐ Engineering ☐ Quality ☐ Other </td> </tr> </table>	☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite	☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	☐ Engineering ☐ Quality ☐ Other
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		MRB (QSI042) Approval _____ Disposition _____			
		Completed By _____			
		Lead hand / Supervisor Approval Verification _____			
		QC / QA Coordinator Approval _____			

Environment
☐ Design
☐ Doc/Data
☐ Equip/Tooling
☐ Handling/Pre
☐ Material
☐ Internal Transport
☐ Tribal Knowledge
☐ LOA
☐ Substation
☐ Past Expiry Date
☐ Misidentified

Offset/Setup
☐ Supplier
☐ Training
☐ Use for Testing
☐ Poor Information
☐ Rushing
☐ Product Improvement
☐ Process Improvement
☐ Manufacturing Process
☐ Past Due

OTHER :
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

Dart Aerospace Ltd.
 1270 Abaddon Street
 Newark, ON L6A 1K7
 CANADA
 TEL: 905 882-5200
 Email: sales@dartaero.com
 www.dartaero.com



Container No: S091216

Part: D3065-5

Job No: 180484

Serial No/Batch: S091216

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/12/18

7	Step Log	1.205inches ± 0.005	1.210 1.200	1,205
8	Step Log	3.484inches ± 0.005	3.489 3.479	3,485
9	Step Log	0.871inches ± 0.005	0.876 0.866	0,872
10	Step Log	8.325inches ± 0.010	8.335 8.315	8,328
11	Step Log	0.551inches ± 0.010	0.561 0.541	0,555
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213	0,213
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128	0,128

Plex 7/6/18 1:35 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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